

Date: Tuesday, 1/23/2007 7:32:58 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WHEEL ASSEMBLY
Job Number	: 30391		
Estimate Number	: 12100		
P.O. Number	: <i>N/A</i>	Part Number	: D3397041
This Issue	: 1/23/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3397 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 29894	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 2/5/2007
Checked & Approved By	: <i>[Signature]</i> 07.01.23	Qty:	12 Um: Each
Comment	: est rev. A new issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3397041	wheel ass'y
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Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)  
 wheel ass'y

2.0	OUTSIDE SERVICE	OUTSIDE SERVICES
-----	-----------------	------------------



Comment: Sub-Contracting PURCHASING  
 Issue P/O: *2934*  
 Order Part #4997T28 from McMaster-Carr as per Dwg D3397  
 Ensure Certificate of Conformity is attached

*07/01/24* (12)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure certificate of conformity is attached

*07/01/26* (10) *07/01/29* (2)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK  
 Ensure certification comply to Dwg D3397

*07.01.31* (12)

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1  
 1-Remove retainers and bearing from wheel, do not damage retainers, discard bearing.  
 2-Ship retainers to machining

*07.01.31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: WHEEL ASSEMBLY

Job Number: 30391

Part Number: D3397041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LATHE CONV.

CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE

1-Turn as per Dwg D3397

2-Deburr

IDENTIFY AS D3397-3

*mk*

*07/02/04*

*12*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*En 07/02/06*

*(12)*

8.0

D33975

sleeve



Comment: Qty.: 1.0000 (s)/Unit Total: 12.0000 (s)

Pick:

Qty Part number Description  
1 D3397-5 sleeve

batch *B30585*  
*D30211-1*

*Cpl 07.02.12*

*(12)*

9.0

HK2820

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part number Description  
2 HK2820 bearing

batch *103482*  
*M103170*

*Cpl 07.02.12*

*(12)*

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Assemble bearing, sleeve and retainers as per dwg D3397

*Cpl 07.02.12*

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*11/07/02/12*

*(12)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*(2)*  
*Cpl 07.02.12*

*12/02/12 (10)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/13

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/23/2007 7:32:58 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL ASSEMBLY

Job Number: 30391

Part Number: D3397041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

7/02/13

Job Completion



C207102112

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

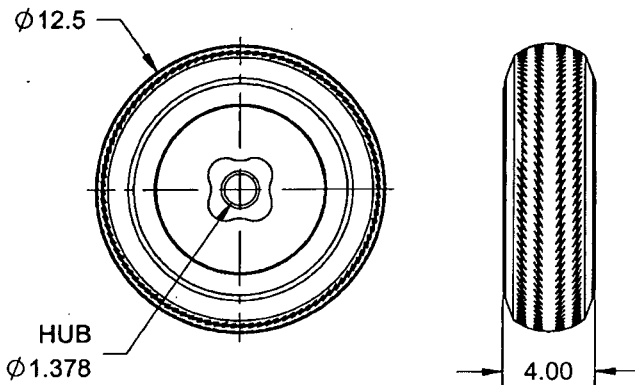
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

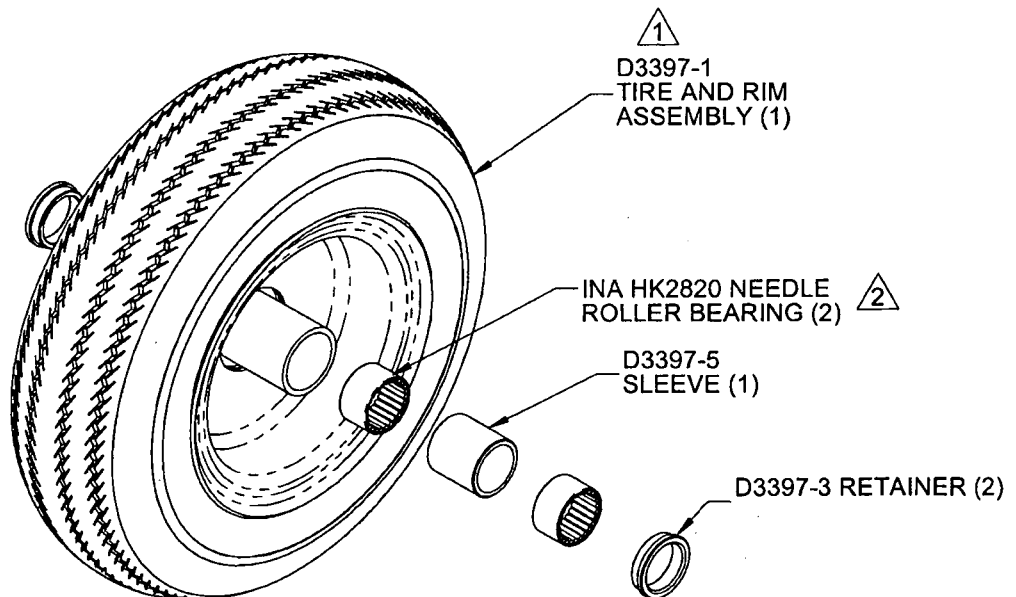
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3397</b>	REV. A SHEET 1 OF 3
DATE <b>05.02.10</b>	TITLE <b>WHEEL ASSEMBLY</b>		SCALE 1:8
A	05.02.10	NEW ISSUE	



WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: Ø12.4 X 4.1 RIM: Ø6.0 X 4.0	445 LBS	50 PSI*

**1 D3397-1 TIRE AND RIM ASS'Y**

**RELEASED**  
06/03/07



**D3397-041 WHEEL ASS'Y**

**NOTES:**

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 4997T28. SCRAP ORIGINAL BEARING
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) INFLATE TIRE TO MAX. 50 psi
- 7) APPLY RUST INHIBITOR NOT PROTECTED BY PAINT. RUST INHIBITOR P/N: LPSC30316

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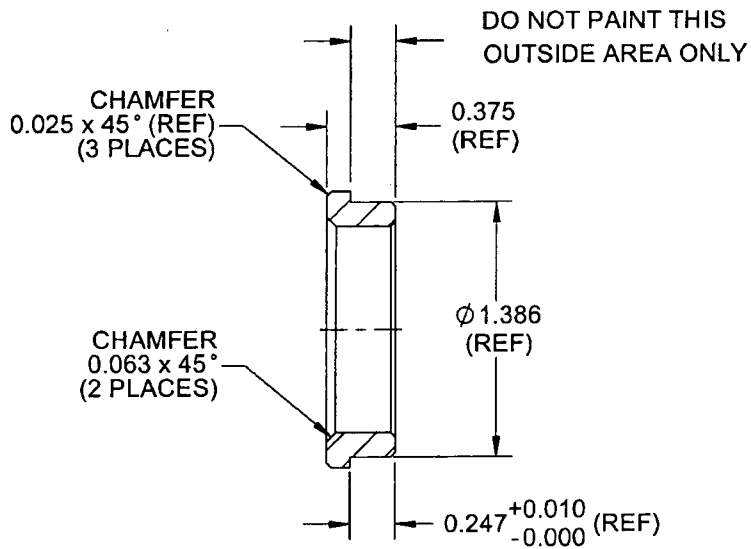


**DART**

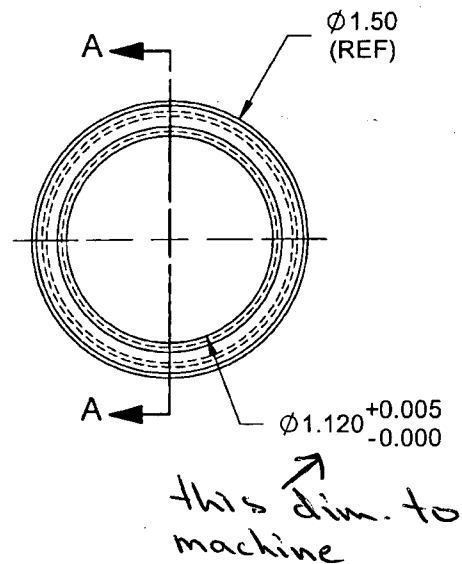
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DATE 05.02.10	TITLE WHEEL ASSEMBLY		SCALE 1:1

**RELEASED**  
06/23/09

## SPECIFICATION CONTROL DRAWING



SECTION A-A



### D3397-3 RETAINER

#### NOTES:

- 1) MATERIAL: REMOVE FROM McMASTER-CARR P/N 4997T28 AND MODIFY AS SHOWN
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.025

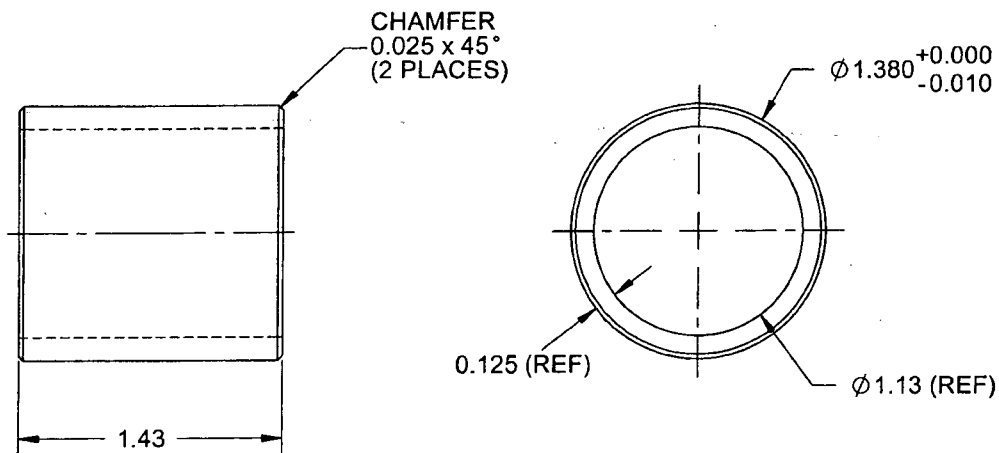
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DATE <b>05.02.10</b>		TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1:1

**RELEASED**  
R 36/02/03**D3397-5 SLEEVE****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 ENGINEERING  
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS  
(REF. DART SPEC. M1020TR1.375W.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.025

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3 DART AEROSPACE LTD  
1230 ABERDEEN ST  
HAWKESBURY ON K6A 1

**YOUR PURCHASE  
ORDER NUMBER**  
P000002934  
Today's Date: 1/24/07

MCMASTER-CARR  
200 AURORA INDUSTRIAL PKWY  
AURORA OH 44202  
IF THERE ARE ANY QUESTIONS ABOUT THIS  
SHIPMENT CONTACT OUR SALES DEPARTMENT  
(330) 995-5500

**PAGE  
1 OF 1**  
**MCM NUMBER**  
8315299-02

Warehouse Location	McMaster Carr Part Number	Fill Quantity	Item Description	Your Line	Your Order	This Shipment
1-332-03-06-80	7630 A23	10 RL	HIGH-TEMP POLYESTER MASKING TAPE 2" WIDE X 72 YARDS LONG	2	10 RL	10
8- 21	4997 T28	10 EA	PNEUMATIC WHEEL WITH TWO-PIECE RIM 12.4" X 3.6", CENTER HUB, 1" AXLE, ROLLER BRNG, 440#CAP 82-RAS  Balance of 2 EA shipped today from another McMaster-Carr warehouse	1	12 EA	10
						209

9 DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY ON K6A 1

**YOUR PURCHASE  
ORDER NUMBER**

P000002936

Today's Date: 1/24/07

McMASTER-CARR  
200 AURORA INDUSTRIAL PKWY  
AURORA OH 44202

IF THERE ARE ANY QUESTIONS ABOUT THIS  
SHIPMENT CONTACT OUR SALES DEPARTMENT  
(330)995-5500

**PAGE**  
**1 OF 1**  
**MCM NUMBER**  
**8315299-01**

Warehouse Location	McMaster-Carr Part Number	Fill Quantity	Item Description	Your Line	Your Order	This Shipment
✓ 8-327-49	50-874997 T28	2 EA	PNEUMATIC WHEEL WITH TWO-PIECE RIM 12.4" X 3.6", CENTER HUB, 1" AXLE, ROLLER BEARING 440WCAP 16 PAK Balance of 10 EA shipped today from another McMaster-Carr warehouse	1	12 EA	2
	7630 A23	*****	Information about the rest of your order  HIGH-TEMP POLYESTER MASKING TAPE Shipped 10 RL today from another McMaster-Carr warehouse	2	10 RL	

McMASTER-CARR PACKING LIST